



## **AGS 3000 Automatic Seam Saw**



## **QUICK OPERATING GUIDE V2.1**

### **CMC-KUHNKE Worldwide**

CMC-KUHNKE, Inc.  
250 Falls Road, Hudson, New York 12534, USA  
Phone: 518-828-9345, Fax: 518-828-8580  
[support@cmc-kuhnke.com](mailto:support@cmc-kuhnke.com)

### **[www.CMC-KUHNKE.com](http://www.CMC-KUHNKE.com)**

CMC-KUHNKE GmbH  
Tempelhofer Ufer 36, 10963 Berlin, Germany  
Tel: +49-30-23 00 66 – 0, Fax: +49-30-23 00 66 – 66  
[support@cmc-kuhnke.de](mailto:support@cmc-kuhnke.de)

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## 1 Customer's Information

- We thank you for the purchase of our Seam Circular Saw AGS 3000 and wish you successful working.
- Please read this manual carefully and follow all accident prevention measures of your company and professional bodies.
- First read this manual and inform yourself  
- afterwards start the saw !
- **Meaning of the warning and mandatory signs:**



## 2 Definition of use

- This seam circular saw was developed especially to cut open can seams for quality inspection.
- It is prohibited to saw other materials!
- Persons, who have not been instructed carefully by an expert are not allowed to use the saw.
- The seam saw is to be used in dry rooms exclusively.



## 3 Warranty

The warranty period is 12 months from delivery date and does not include consumption material, wear, and exterior force. All complaints deriving from transportation damages must be forwarded immediately to the shipper together with the original packaging, because the supplier is not liable for freight damages.

## **4 Before you start the saw**

- The saw is delivered completely with two saw blades, type 100x22x0,5mm, HSS nitrited, mounted.
- Please check whether the necessary power supply is available. Compare this with the type designation.
- Do not start the saw before all these instructions have been read carefully. Also observe the security information of the following paragraphs.

## **5 Safety information for place and connection**

- The directions of "Rules for Prevention of Accidents (RPA)", VDE and DIN as well as your country's specific directions and laws must be observed for the operation of the saw.
- Any mechanical or electrical modification on the machine, which does not follow the ruling directions, is prohibited.
- The saw must be used on a safe and firm place on a working table exclusively. Due to the noise emission it should be installed in a room where it is of no danger to other workers.
- The saw may not be installed in halls, corridors or similar in order to prevent the operator from distraction and reduce noise bothering.
- The saw is not designed for damp rooms and must not be cleaned wet.
- Outlets must be in accordance with the security directions.
- When pulling out of the outlet always pull the cable at the plug and never only at the cable.
- The outlet must be grounded. We recommend the use of a thermo magnetically safe fuse.

## **6 Security Information for the period of operation**

- Check all security installations whether they are still working and in a firm position.
- If the blade jams in the can please turn off the machine and draw the slide back.



- Front view with open hood

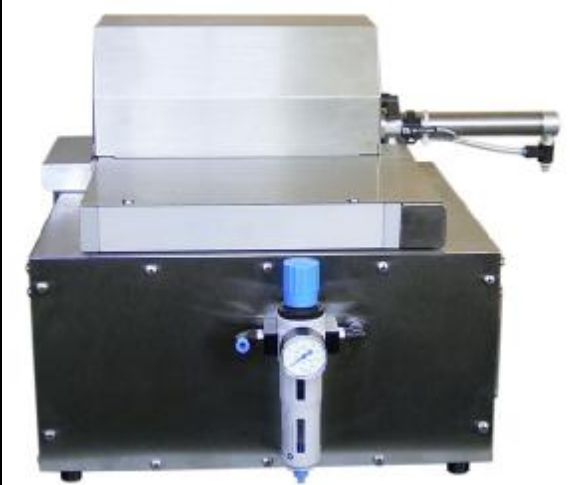


- Front view with hood closed

## 7 Short description: Setup



- **Front view**  
**Attention: during the connection process some parts of the machine may move. Please observe to have your fingers off the machine during this.**



- **Rear view with compressed air service unit**
- Make sure the saw is connected to **min. 80 psi** (5,5 bar) air pressure (6mm outside diameter tube) at the rear of the saw,
- Connect it to 115 V, 60Hz power.
- Select the correct TOOLING for the can size you want to cut



- **Front view with left side**  
Please make sure to set the **clamping pressure** to min. **44 psi** at the flow control valve at the left side of the machine
- This can only be controlled when the machine is running..



- The built in Siemens control box is approximately after 5 seconds boot phase ready to go, after the following conditions have been self-tested:
  1. E-STOP has not been pushed;
  2. The blade guard has not been removed; and
  3. The FI-safety switch has not been actuated.



- The ON-OFF Switch serves as well as a status indicator of the machine:
  - permanent GREEN indicates that the machine is READY
  - blinking green indicates that there is a problem (please refer to the trouble shooting guide). In this case you may read the cause for the problem at the LCD DISPLAY in the SIEMENS LOGO control box at the left side.
- Push the green button to start the saw. The indicator will not light during this operation
- As soon as the green button lights permanently again, the saw cut 'cycle has been made successfully and indicates that the next cut can be made
- The cut movement can be interrupted ANY TIME by pressing the STOP button RED
- If you do this, then the green light indicator will flash in 0,5 second intervals. You may now read in the display of the SIEMENS LOGO control box for the possible cause of the error.
- Important: You have to CONFIRM the error to go on with the next saw cut by pressing the RED Stop button



## 8 Work instructions



- Make sure the saw is connected to min. 80 psi (5,5 bar) air pressure, 115 V power.
- Select the correct TOOLING for the can size you want to cut



- Open the hood



- Take a can, e.g. dia. 603





- Put it into the saw and close the hood
- Start the cut by pressing the green button on the left hand side
- The saw will cut the can by moving to the right over the saw blades.



- When finished, the slide retracts and the can may be taken out
- The can is now cut and the remaining piece between the 2 cuts is dented in to ensure immediate seam inspection

## 9 How to change the tooling for different can diameters



- 3 different tooling are available for specific can diameters between 211 to 603 cans, which may be exchanged within seconds



- To change the tooling, loose the black lock at he left side of the hood as in the picture



- Take the tooling out



- Take a different tooling and insert it into the frame.



- Make sure to tighten the tooling lock again safely.



- You may now cut a different can diameter, e.g. a 211 can.

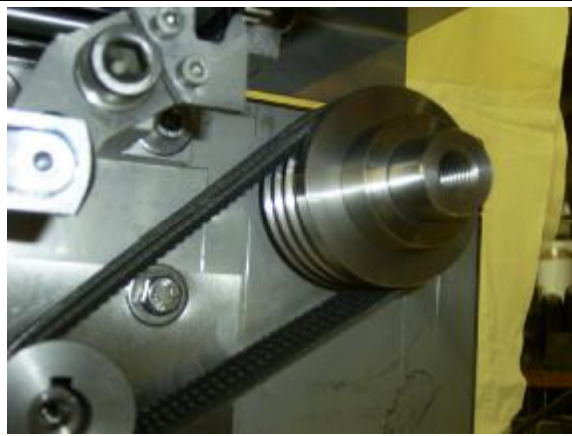
## 10 How to change the saw blades



- Take off the front right stainless steel box by loosening the 2 screws at the bottom of the right hand side of the saw and take this piece off.



- You have now access to the saw blades and the indenting nose.
- The picture shows the saw without blades



- Put the round spacer on the shaft



- Put the first saw blade on the shaft



- Put the spacer on the shaft





- Put the 2<sup>nd</sup> saw blade on the shaft



- Put the distance ring on the shaft



- Mount the screw firmly onto the shaft



- Tighten the screws as can be seen on the picture



- Put back the stainless steel housing in place to cover the area



## 11 How to change the forward travel speed (cutting speed)



- Changes in the forward travel speed should only be done by authorized personnel.
- Remove the saw cover



- This one way flow control valve is responsible for the speed.
- If you alter the cutting speed, test it without a can in the saw.